

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave.St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001667**Date Inspected:** 06-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Or**CWI Name:** Greg Roberts**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge K Pipe Beam (62F)**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Danny C. White (B89) was present at Oregon Iron Works (OIW) for the purpose of monitoring fabrication operations of the Hinge K at the OIW fabrication and welding shop in Clackamas, Oregon.

The QA Inspector met with project Production Manager Mr. Bill Pender and Welding Engineer and Certified Welding Inspector (CWI) Mr. Greg Roberts to observe the current fabrication Oregon Iron Works has performed thus so far concerning the Hinge K Pipe Beam. The QA Inspector observed that OIW welding operators are performing bevel operations on stiffener plates as well as pipe components by utilizing automatic track type torches in the fabrication shop (Bay #1) and a vertical turret lathe (VTL) in the machine shop (Bay #5). See photos below for additional information. The QA Inspector performed random observation of several variety's of parts for the Hinge K and the work observed appear to comply with the drawings specifications. The QA Inspector was informed that welding operations have been performed on the procedure qualification record (PQR) test plates and are awaiting testing.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

Within the body of the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: White,Danny

Quality Assurance Inspector

Reviewed By: Wright,Mark

QA Reviewer